



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBE350A94-2706-00-05

Job Sheet 196130



Part No: RBE350A94-2706-00-05

Job Qty: 8 pcs

Part Name: Pin



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/7/19

Job Tracking No:

Due Date: 6/28/19

Created By: Marie Lajeunesse

Type: Stock

Description: SIOP

Note: DWG RBE350A94-2706-00 REV 6 IPP REV A 18-01-16 NEW ISSUE JFC VERIFIED DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Small Fab - 1	8 pcs	6/28/19		0.00	0.53	Small Fab - 1		
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		Bm
							Small Fab - 7		
120	QC 5	8 pcs	6/28/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
121	Outsource - 12 - Black Oxide	8 pcs	6/28/19				QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							GRO002-VC	10	
							Packaging 2 - 1 - B4B		
							Packaging 2 - 2 - B4B		
123	Packaging 2-1 - Receive - B4B	8 pcs	6/28/19		0.00	0.00	Packaging 2 - 3 - B4B		
							Packaging 2 - 5 - B4B		
							Packaging 2 - 4 - B4B		
							Packaging 2 - 6 - B4B		



Dart Aerospace Ltd.
1270 Aberdeen Street
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CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S194497



Part: RBE350A94 - 2706 - 00 - 05

Job No: 196130

Serial No/Batch: S194497

Revision: 6

Inspector:

Exp Date:

Instructions:

Date: 07/11/19

DAS
40
9-89

JUN 27 2019

2019-07-02

JUL 11 2019

Plex 6/7/19 8:53 AM Dart.lajeunesse.marie

				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
125 QC 6	8 pcs	6/28/19	0.00 0.00	QC 6 - 9	DAS 81 9-89
				QC 6 - 68	
				QC 6 - 61	
				QC 6 - 40	
127 Small Fab - 2 - B4B	8 pcs	6/28/19	0.00 0.67	Small Fab - 1 - B4B	JUL 11 2019
				Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
129 QC 5	8 pcs	6/28/19	0.00 0.00	QC 5 - 10	DAS 40 9-89
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
130 Packaging 3-1 - Stock - B4B	8 pcs	6/28/19	0.00 0.00	Packaging 3 - 1 - B4B	JUL 11 2019

					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
140	QC 21 - SA	8 pcs	6/28/19	0.00 0.00	QC 21 - SA - 21	
					QC 21 - SA - 70	JUL 12 2019
					QC 21 - SA - 53	

GA 141 A

Part Op 110 - (Small Fab) - Assemble as per DWG. Sheet 2 - Loctite 680 B 5190051 Exp: 12/31/2020
 Descriptions: 120 - (QC5- Inspect part completeness to step on W/O)
 121 - Issue P/O to Groupe Altech; PO 43885 - Black oxide finish, MIL-C-13924C Class 1 - Certificate of Conformity is required
 123 - (Receive & Inspect for Damage & Mat'l Certs)
 125 - (QC6- All purchased or subcontracted products)
 127 - (Small Fab) - Fabricate lanyard 6 inch and Assemble as per DWG
 129 - (QC5- Inspect part completeness to step on W/O)
 130 - (Identify as per dwg & Stock Location: _____)
 140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
91595A142	Dowel Pin Ø3mm x 40mm	8 Ea (1 ea)	110-Small Fab - 1	<u>5161550</u>
RBE350A94-2706-00-05A	Pin Shaft	8 pcs (1 ea)	110-Small Fab - 1	<u>509 2225</u>
3896T31 <u>026</u>	Ferule 1/16 X 3/8" - Aluminum	16 Ea (2 ea)	127-Small Fab - 2 - B4B	<u>509 2609</u>
CL-2-C <u>026</u>	Lanyard Wire	4 ft (.5 ea)	127-Small Fab - 2 - B4B	<u>5150824</u>
NAS1756-12 <u>025</u>	Remove Before Flight	8 Ea (1 ea)	127-Small Fab - 2 - B4B	<u>5192012</u> <u>5055 792.</u>

M.U. 010865

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Small Fab - 1	91595A142	8	105	0
	RBE350A94-2706-00-05A	8	8	0
127-Small Fab - 2 - B4B	3896T31	16	651	0
	CL-2-C	4	87	0
	NAS1756-12	8	194	0
Part Specifications				
Specifications could not be found.				

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Container No: S194497



Part: RBE350A94-2706-00-05

Job No: 196130

Serial No/Batch: S194497

Revision: 6

Inspector:

Exp Date:

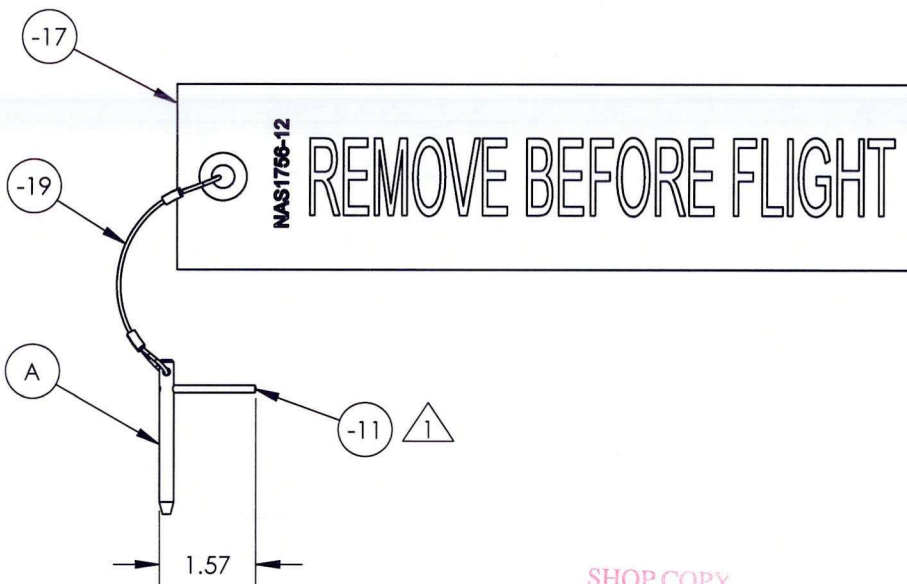
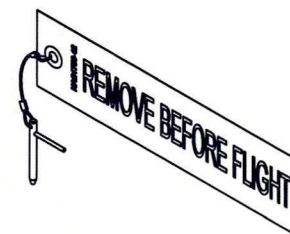
Instructions:

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TEL.: 1 613 632-5200
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www.dartaerospace.com

Date: 06/27/19

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REVISIONS				DATE	INITIAL	APPROVED
REV	ECR	DESCRIPTION				
6	16-0281	-01, -03, -05, -07, -09 ADDED FINISH SPEC QSMI-6.2.2, B.O. REV D. ADDED -17, -19, NOTE 1		1/12/2017	RJC	JAG



ASSY P/N	A P/N
-01	-01A
-03	-03A
-05	-05A
-07	-07A
-09	-09A

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 196130 MJS
190608

-01, -03, -05, -07, -09

PIN

NOTE:

1 USE LOCTITE 680 TO ASSEMBLE.

DART AEROSPACE	
TITLE RIGGING PIN SET	
DWG NO. RBE350A94-2706-00-01	REV 6
MAT'L QSMI-6.2.2, B.O. REV D	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT BLACK OXIDE	.XXX ± .005 FRACTIONS ± 1/8
FINISH BLACK OXIDE	.XX ± .01 ANGLES ± 5°
	.X ± .1 SURFACES = 125
SPEC QSMI-6.2.2, B.O. REV D	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: PERRITT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: DUERFELDT	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	EUROCOPTER AS350/355
SCALE 1:3	DATE 9/11/2009
SHEET 2 OF 3	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Dart Aerospace Ltd.
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K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB043885



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB043885

PO Date: 7/2/19

Due Date: 7/9/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

E-MAILED
2019-07-03

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	196135	RBE1X36-176-779-1	Sleeve (Outside Processing - Black Oxide) -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; O1 -Certificate of Conformity is required	Firmed	-	7/9/19	3 pcs	0 pcs	3 pcs	\$3.4285/pcs	\$10.29
							3 x				
							JUL 11 2019				
2	194625	RB6799790	Engine Turning Adapter -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed	-	7/9/19	5 pcs	0 pcs	5 pcs	\$3.4285/pcs	\$17.14
							5 x				
							JUL 11 2019				



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PURCHASE ORDER

POHB043885



Items												
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price	
3	194688	RBA8100-80902-1	Wrench -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed	-	7/9/19	7 pcs	0 pcs	7 pcs	\$3.4285/pcs	\$24.00	
4	196608	RBEL133M-6201-101-15	Forcing Screw -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed	-	7/9/19	6 pcs	0 pcs	6 pcs	\$3.4285/pcs	\$20.57	
5	196609	RBEL133M-6201-101-17	Screw Cap -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed	-	7/9/19	6 pcs	0 pcs	6 pcs	\$3.4285/pcs	\$20.57	
6	196130	RBE350A94-2706-00-05	Pin -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	7/9/19	8 pcs	0 pcs	8 pcs	\$3.4285/pcs	\$27.43	
Grand Total:											\$120.00	



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PURCHASE ORDER

POHB043885



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 7/3/19 2:37 PM Dart.Guerin.Kimberley



Certificat de Conformité / Certificate of Compliance

(020441-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupealtech.com

Bon de Livraison / Packing Slip

020441 - 1

Livré à / Ship to

DART AEROSPACE LTD

1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA

Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD

1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA

BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
10-Jul-2019		SVETLANA DORZHIYEVA		POHB043885				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBE1X36-176-779-1 Rev.	RBE1X36-176-779-1 OXIDE-BLK & OIL [OXIDE BLACK AND OIL] APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3, CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS	OXIDE-BLACK CH	3	3	0	0	0
2	RB6799790 Rev.	RB6799790 OXIDE-BLK & OIL [OXIDE BLACK AND OIL] APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3, CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS	OXIDE-BLACK CH	5	5	0	0	0
3	RBA8100-80902-1 Rev.	RBA8100-80902-1 OXIDE-BLK & OIL [OXIDE BLACK AND OIL] APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3, CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS	BLACK-OXIDE CH	7	7	0	0	0
4	RBEL133M-6201-101-15 Rev.	RBEL133M-6201-101-15 OXIDE-BLK & OIL [OXIDE BLACK AND OIL] APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3, CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS	OXIDE-BLACK CH	6	6	0	0	0
5	RBEL133M-6201-101-17 Rev.	RBEL133M-6201-101-17 OXIDE-BLK & OIL [OXIDE BLACK AND OIL] APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3, CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS	OXIDE-BLACK CH	6	6	0	0	0
6	RBE350A94-2706-00-05 Rev.	RBE350A94-2706-00-05 01 -OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	OXIDE-BLACK CH	8	8	0	0	0

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